

Work Order ID 63148

Thursday, October 21, 2010 3:02:25 PM

Page 1

Item ID: D350-636-215

Accept

Revision ID:

Item Name: Skidtube STD LH, Deluxe

Start Date: 10/21/2010 Start Qty: 1.00

Required Date: 10/28/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

10-10-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPPD350-636-215 CHG001

Sulodog

110

Assemble as per dwg

0.00



HandFinish

Hand Finishing

Memo

0.00

1- Assemble Toe kit, Wedge kit and Tow ring kit to D350-636-015 as per IIN-D350-636

TO 11/01/06

PTO

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

Sulodog

(H)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D350-636-215 PAR #: _____ Fault Category: sketch NCR: Yes No DQA: _____ Date: 11.01.10
 Resolution: Accepted Disposition: use as is. QA: N/C Closed: OK Date: 11/01/11

| NCR: 631418 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------|------|--|-----------------------------|---------------------------------|----------------|---------------------------|--------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/01/06 | 110 | IFN STATES OPEN HOLE IN SKID TO .625, Tow Ring .635 upon hole in skid TO .642 TO Accomodate Tow Ring | GP 11.07.06 Q81072 | Acceptable | AS 11/01/06 | S 11/01/07 | GP 11.01.06 PS 642 | S 11/01/07 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 63148

Thursday, October 21, 2010 3:02:25 PM

Page 2

Item ID: D350-636-215

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube STD LH, Deluxe

Start Date: 10/21/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-636-215

Location:

PPP rev: *0.00 Pst*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

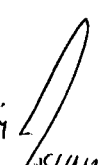





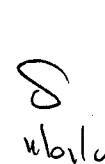
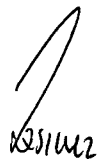
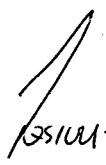
10/21/07

11/01/07

MF
11-01-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D350-636-215 PAR #: _____ Fault Category: Finishing NCR: Yes No DQA: 2 Date: 11/01/07
 Resolution: rework Disposition: rework QA: N/C Closed: ✓ Date: 11/01/07

| NCR: 63148 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---------------|--------|--|---|---|--|--|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| # 11/01/07 | # 1 | Found when clean w/o's that employ had used the incorrect washer when installing the Blade on the Blade Blade Fitt. |  | - Remove AND install correct AN9603D 816 M106043 Qty x2 |  11/01/07 |  |  | |
| | | on w/o 6277 62437. R.L. LOR when installing and lack of train |  | - Retrain + inform employee of issue. Record on JT sheet. | | |  |  |
| | | |  | - work order is clear that AN9603D 816 washer is to be used. 816043 | | |  | |

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, October 21, 2010 3:02:32 PM

Work Order ID: 63148



Parent Item: D350-636-215



Parent Item Name: Skidtube STD LH, Deluxe

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.04 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D350-636-015 | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| Skidtube STD w/ Training Wearplates, LH | | | | | | | | 62437 B627H | | | | 11/01/07 | |
| D350-636-101 | | Manufactured | No | | | 110 | Each | 15.0000 | 1 | 1 | | | |
| Toe Step, LH/RH | | | | | | | | | | | | 11/01/07 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | FG021 | | 15 | | | | | | | |
| | | | | 26089 | | 15 | | | | | | | |
| D350-636-105A | | Manufactured | No | | | 110 | Each | 10.0000 | 1 | 1 | | | |
| Wedge Installation | | | | | | | | | | | | 11/01/07 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | FG021 | | 10 | | | | | | | |
| | | | | 51450 | | 1 | | | | | | | |
| | | | | 51959 | | 4 | | | | | | | |
| | | | | 54958 | | 5 | | | | | | | |
| D350-636-109 | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| Tow Ring Installation | | | | | | | | B627H | | | | 11/01/07 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

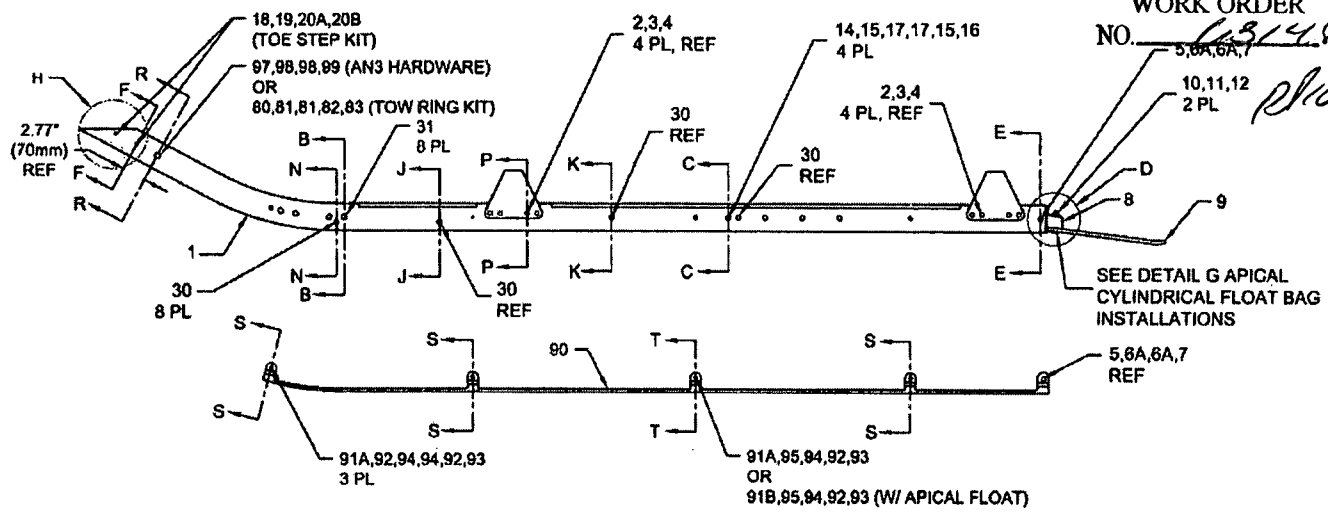
DART AEROSPACE USA, INC.

IIN-D350-636
Page 13 of 31

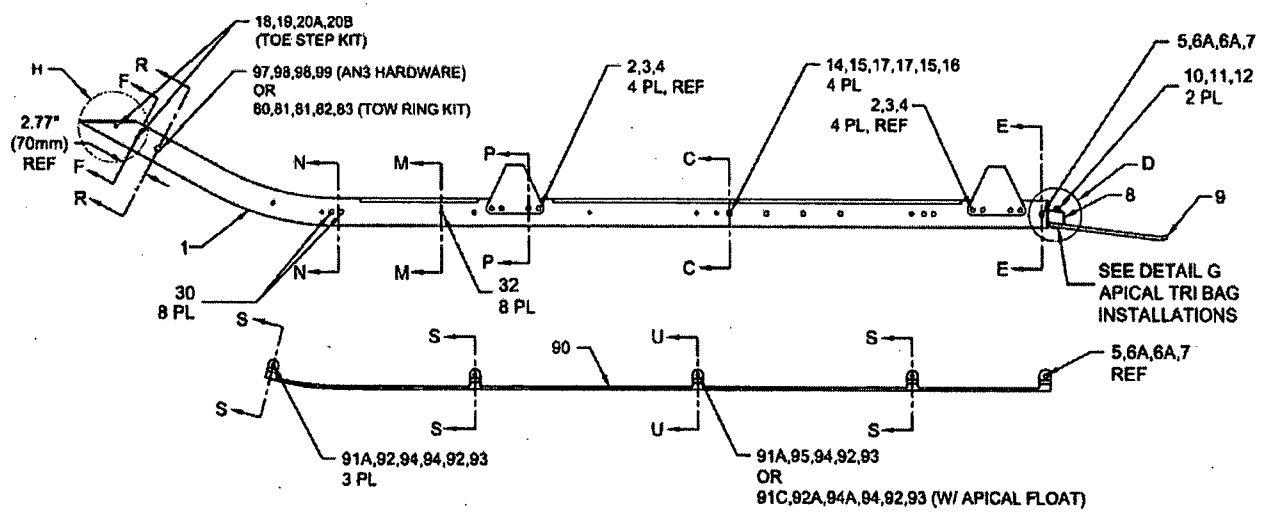
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Revision: H
Date: 10.07.26

Figure 3: D350-636-015/-016/-017/-018/-215/-216/-217/-218 SKIDTUBE ASSEMBLY



D350-636-015/-016/-215/-216
(Aerazur/Apical Cylindrical)



D350-636-017/-018/-217/-218
(Aircruiser/Apical Tri-bag)

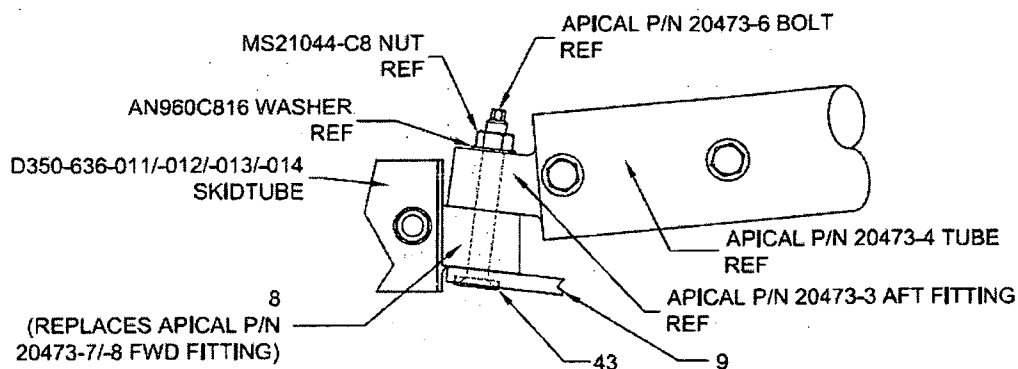
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

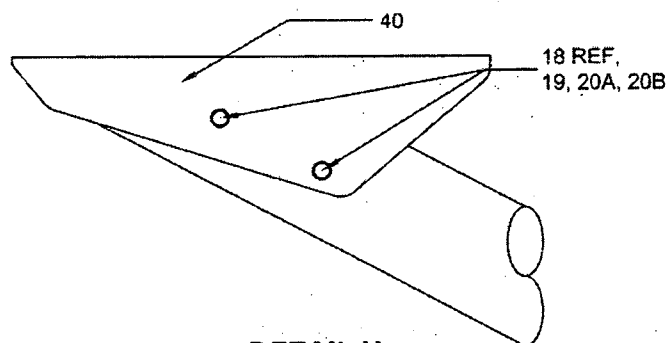
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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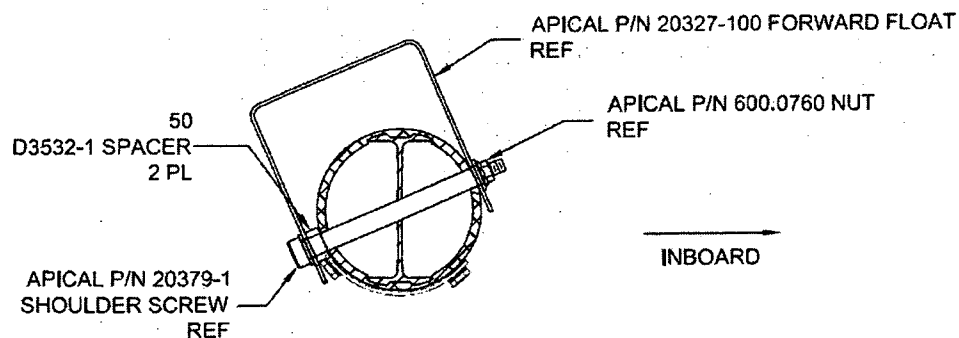
NOTE: Date & initial all entries



DETAIL G
(APICAL CYLINDRICAL AND TRI-BAG INSTALLATIONS)
1 PL PER SKIDTUBE



DETAIL H
(D350-636-101 TOE STEP)
1 PL PER SKIDTUBE



SECTION N-N
(LH SHOWN, RH OPPOSITE)
(D350-636-011/-012 WITH APICAL CYLINDRICAL FLOATS ONLY)

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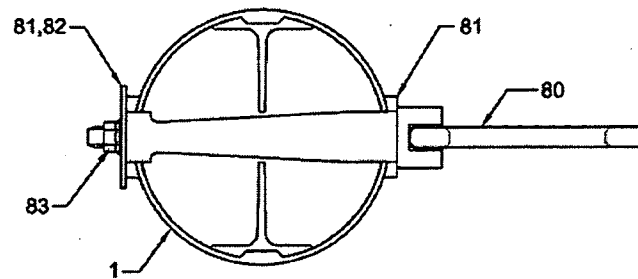
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

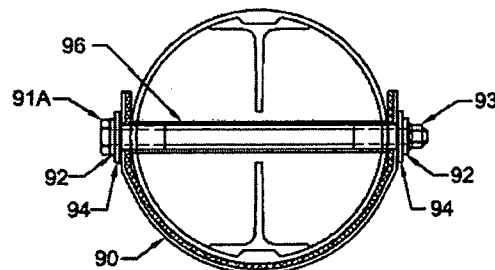
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries



SECTION R-R
SHOWN WITH DRILLED Ø0.625" HOLE &
D350-636-109 TOW RING KIT

u603148



SECTION S-S
D350-636-015/-016/-017/-018/-215/-216/-217/-218
SKIDTUBES, 3 PL

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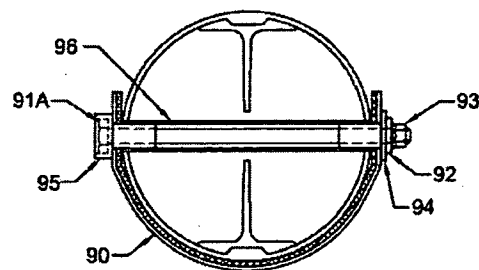
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

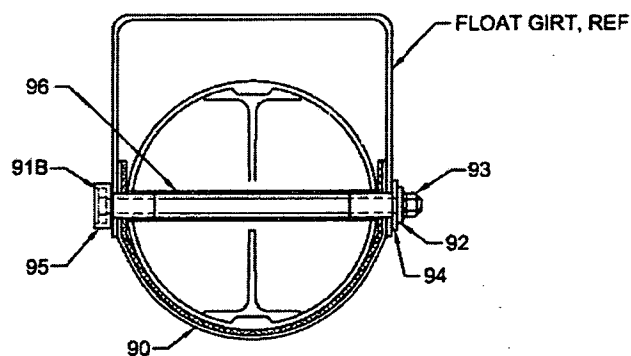
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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



**WITHOUT APICAL CYLINDRICAL BAG
FLOATS**

OR



WITH APICAL CYLINDRICAL BAG FLOATS

u1063148

SECTION T-T
D350-636-015/-016/-215/-216 SKIDTUBES
1 PL

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Revision: **H**
Date: 10.07.26

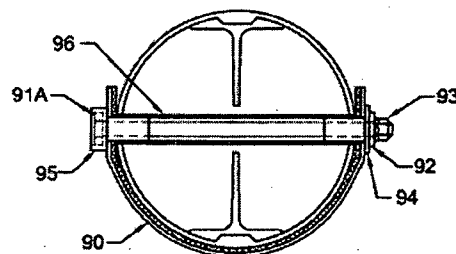
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

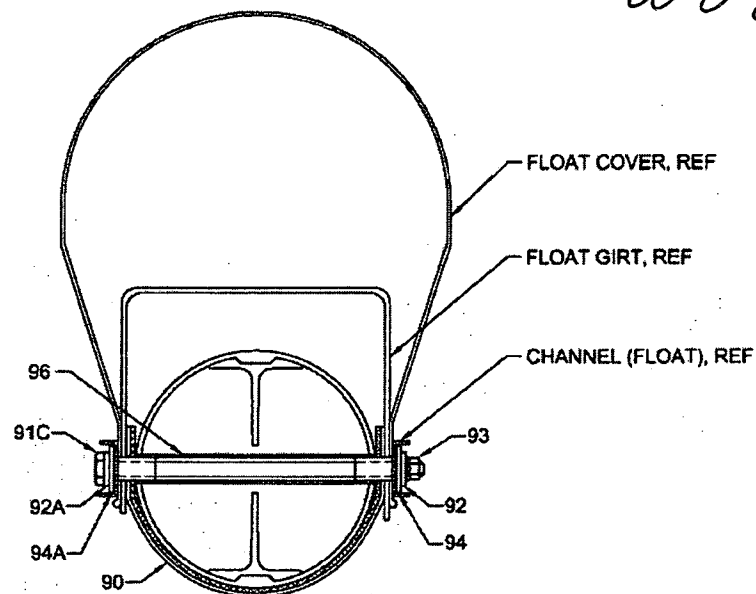
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NOTE: Date & initial all entries



WITHOUT APICAL TRI BAG FLOATS

OR



WITH APICAL TRI BAG FLOATS

SECTION U-U

D350-636-017/-018/-217/-218 SKIDTUBES

1 PL

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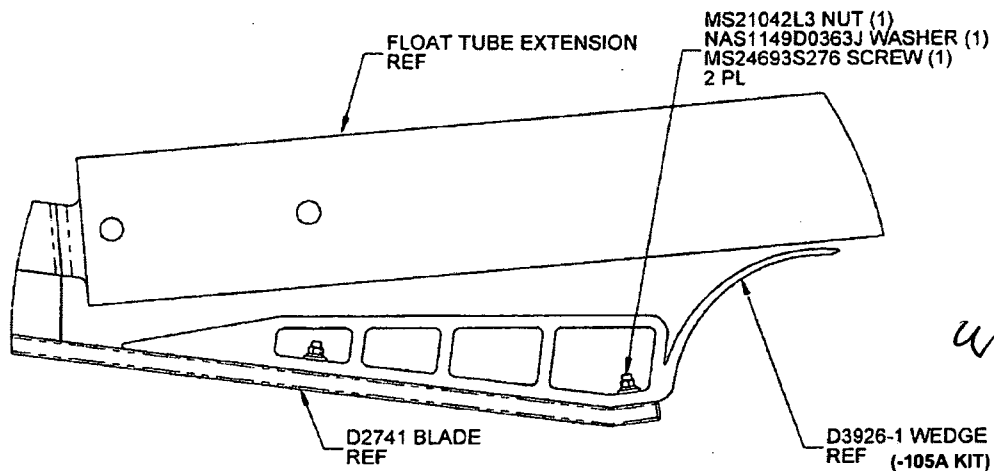
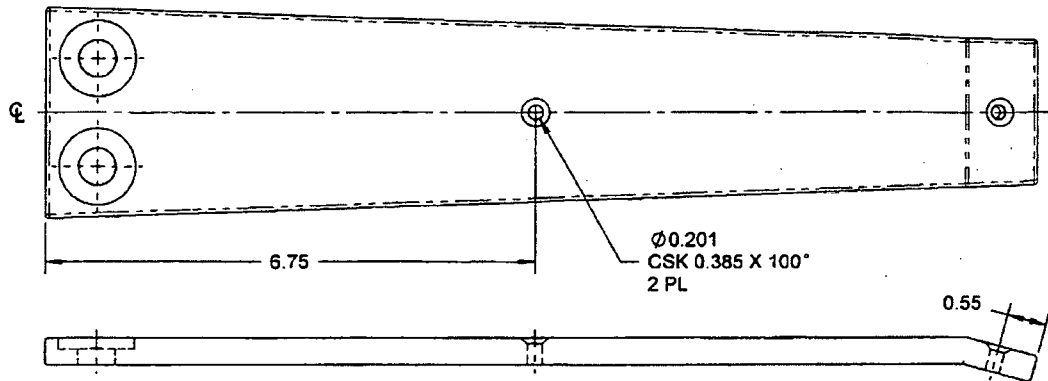
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



w/64348

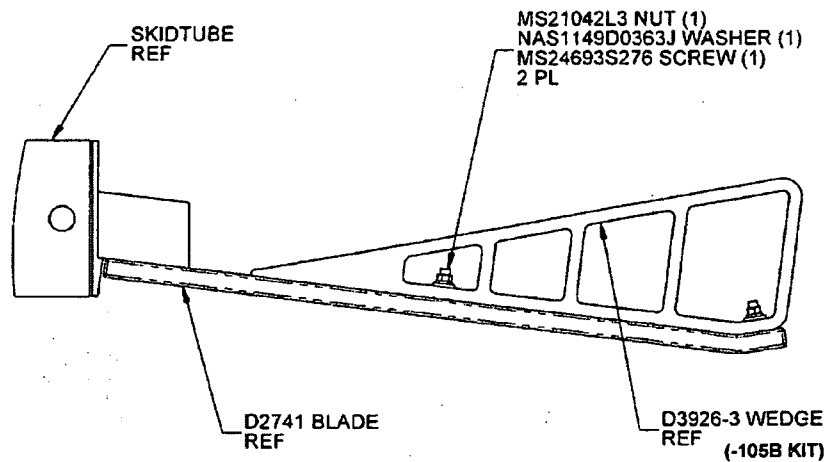


Figure 4: D350-636-105A/-105B WEDGE KIT INSTALLATION

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Revision: **H**
Date: 10.07.26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 63148

Thursday, October 21, 2010 3:02:25 PM



Page 1

Item ID: D350-636-215

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD LH, Deluxe

Start Date: 10/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-10-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

IIN-D350-636

H

0.00

100



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-215 CHG001

11-01-7

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Assemble Toe kit, Wedge kit and Tow ring kit to D350-636-015 as per IIN-D350-636

11/01/06

PTO

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Salazar

(H)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries